

Work Order ID 129067***129067***

Page 1

Wednesday, January 28, 2015 9:06:20 AM

Item ID: D3884-2 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle, Inboard RH
Start Date: 1/28/2015 Start Qty: 8.00 ***8*** Cust Item ID:
Required Date: 1/28/2015 Req'd Qty: 8.00 ***8*** Customer:
Reference:

Approvals: Process Plan: MCS Date: 15-01-28 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3884	B								

100

0.00

100

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program Batch No. 129067Double check by: [Signature]

1-Machine Step No 1 per Folio FA819 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA819 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA819 and inspect per Dimension Sheets

10 0 DAS 44 15/02/28
9-89

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

10 0 DAS 44 15/02/28
9-89

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Item ID: D3884-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, Inboard RH
 Start Date: 1/28/2015 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 1/28/2015 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120						10	0		JFL 2015-3-7
QC	Memo	0.00							
Quality Control									
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130						10	0	15-3-7	DL
HandFinish	Memo	0.00							
Hand Finishing									
140	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
140						10	0	15-3-18.	DAS 34 988
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 11:10 OVEN TEMPERATURE: 320° FINISH TIME: 11:40								

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Wednesday, January 28, 2015 9:06:20 AM

Item ID: D3884-2 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Saddle, Inboard RH
 Start Date: 1/28/2015 Start Qty: 8.00 *8* Cust Item ID:
 Required Date: 1/28/2015 Req'd Qty: 8.00 *8* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00							38 9-89
150						(10)			
QC	Memo	0.00							
Quality Control									MAR 18 2015
160	Identify as per dwg & Stock Location: <u>st 404</u>	0.00							
160						K			DAS 27 9-89
Packaging	Memo	0.00							MAR 19 2015
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									MCS 1503-19 MF 15-3-14

Picklist Print

Wednesday, January 28, 2015 9:06:22 AM

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Work Order ID: 129067

129067

Parent Item: D3884-2

D3884-2

Parent Item Name: Saddle, Inboard RH

Start Date: 1/28/2015

Required Date: 1/28/2015

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-017		Manufactured	No				Each	10.0000		8			
D6101-017									**				
Saddle Billet													

DAS
44
9-89

15/03/01

Location

Loc Qty

Loc Code

MAT040

10

124346

10

10

DART AEROSPACE LTD		Work Order:	129067
Description: Saddle, Inboard, RH		Part Number:	D3884-2
Inspection Dwg: D3884	Rev. B	Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	2.870	2.880		2.875	2.875	2.875	2.875		
B	1.433	1.443		1.438	1.438	1.438	1.438		
C	0.638	0.658		0.646	0.648	0.648	0.648		
D	3.895	3.905		3.900	3.900	3.900	3.900		
E	0.257	0.262		0.258	0.258	0.258	0.258		
F	0.605	0.625		0.615	0.615	0.615	0.615		
G	1.120	1.130		1.125	1.125	1.125	1.125		
H	2.245	2.255		2.250	2.250	2.250	2.250		
I	2.000	2.020		2.005	2.006	2.005	2.0045		
J	0.140	0.175		0.141	0.142	0.141	0.142		
K	1.265	1.285		1.268	1.268	1.270	1.270		
L	0.115	0.135		0.125	0.124	0.125	0.125		
M	0.240	0.260		0.244	0.249	0.250	0.250		
N	0.110	0.140		0.135	0.135	0.135	0.135		
O	0.240	0.260		0.249	0.250	0.250	0.249		
P	2.826	2.886		2.866	2.867	2.867	2.867		
Q	0.178	0.198		0.188	0.188	0.188	0.188		
R	0.140	0.165		0.148	0.150	0.150	0.151		
S	0.720	0.780		0.750	0.750	0.750	0.750		
T	1.220	1.280		1.256	1.257	1.257	1.257		
U	1.245	1.255		1.250	1.250	1.250	1.250		
V	5.990	6.010		6.001	6.002	6.002	6.002		
W	2.495	2.505		2.500	2.500	2.500	2.500		
X	0.490	0.510		0.500	0.500	0.500	0.500		
Y	0.020	0.040		0.025	0.025	0.025	0.025		
Z	0.313	0.318		0.314	0.314	0.314	0.314		
AA	0.760	0.765		0.760	0.760	0.760	0.760		
AB	0.215	0.220		0.218	0.218	0.218	0.218		
AC	0.316	0.321		0.316	0.316	0.316	0.316		
AD	1.745	1.755		1.750	1.750	1.750	1.750		
AE	0.990	1.010		1.003	1.005	1.004	1.004		
AF									
Accept/Reject									

Measured by:	FK
Date:	15/03/01

Audited by:	JFC
Date:	2015-3-7

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	

DART AEROSPACE LTD		Work Order:	129067
Description: Saddle, Inboard, RH		Part Number:	D3884-2
Inspection Dwg: D3884 Rev. B		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				5	6	7	8		
A	2.870	2.880		2.875	2.875	2.875	2.875		
B	1.433	1.443		1.438	1.438	1.438	1.438		
C	0.638	0.658		.648	.648	.648	.647		
D	3.895	3.905		3.900	3.900	3.900	3.900		
E	0.257	0.262		.258	.258	.258	.258		
F	0.605	0.625		.615	.615	.615	.615		
G	1.120	1.130		1.125	1.125	1.125	1.125		
H	2.245	2.255		2.250	2.250	2.250	2.250		
I	2.000	2.020		2.004	2.003	2.007	2.006		
J	0.140	0.175		.142	.142	.141	.142		
K	1.265	1.285		1.268	1.270	1.2685	1.268		
L	0.115	0.135		.125	.126	.124	.124		
M	0.240	0.260		.249	.251	.250	.250		
N	0.110	0.140		.135	.135	.135	.135		
O	0.240	0.260		.250	.248	.251	.250		
P	2.826	2.886		2.868	2.868	2.867	2.867		
Q	0.178	0.198		.188	.188	.188	.188		
R	0.140	0.165		.150	.151	.152	.151		
S	0.720	0.780		.750	.750	.750	.750		
T	1.220	1.280		1.257	1.258	1.258	1.258		
U	1.245	1.255		1.250	1.250	1.250	1.250		
V	5.990	6.010		6.002	6.002	6.002	6.002		
W	2.495	2.505		2.500	2.500	2.500	2.500		
X	0.490	0.510		.500	.501	.501	.500		
Y	0.020	0.040		.025	.025	.025	.025		
Z	0.313	0.318		.314	.314	.314	.314		
AA	0.760	0.765		.760	.760	.760	.760		
AB	0.215	0.220		.218	.218	.218	.218		
AC	0.316	0.321		.316	.316	.316	.316		
AD	1.745	1.755		1.750	1.750	1.750	1.750		
AE	0.990	1.010		1.004	1.005	1.004	1.004		
AF									
Accept/Reject									

Measured by:	FL
Date:	15/03/02

Audited by:	JFC
Date:	2005-3-7

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	

DART AEROSPACE LTD		Work Order: 129067
Description: Saddle, Inboard, RH		Part Number: D3884-2
Inspection Dwg: D3884	Rev. B	Page 1 of 1

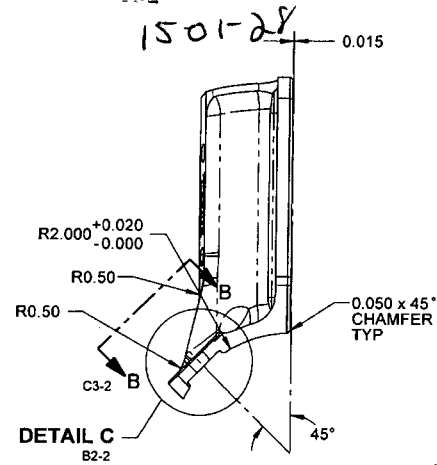
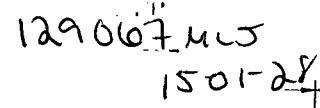
Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				9	10	3	4		
A	2.870	2.880		2.875	2.895				
B	1.433	1.443		1.438	1.438				
C	0.638	0.658		.647	.647				
D	3.895	3.905		3.900	3.980				
E	0.257	0.262		.258	.257				
F	0.605	0.625		.615	.615				
G	1.120	1.130		1.125	1.125				
H	2.245	2.255		2.250	2.250				
I	2.000	2.020		2.006	2.005				
J	0.140	0.175		.145	.143				
K	1.265	1.285		1.270	1.270				
L	0.115	0.135		.125	.124				
M	0.240	0.260		.250	.250				
N	0.110	0.140		.135	.135				
O	0.240	0.260		.249	.250				
P	2.826	2.886		2.867	2.867				
Q	0.178	0.198		.188	.188				
R	0.140	0.165		.152	.152				
S	0.720	0.780		.750	.750				
T	1.220	1.280		1.258	1.258				
U	1.245	1.255		1.250	1.250				
V	5.990	6.010		6.002	6.002				
W	2.495	2.505		2.500	2.500				
X	0.490	0.510		.500	.500				
Y	0.020	0.040		.025	.025				
Z	0.313	0.318		.314	.314				
AA	0.760	0.765		.760	.760				
AB	0.215	0.220		.218	.218				
AC	0.316	0.321		.316	.316				
AD	1.745	1.755		1.750	1.750				
AE	0.990	1.010		1.004	1.004				
AF									
Accept/Reject									

Measured by:	FK
Date:	15/03/02

Audited by:	JH
Date:	2005-3-7

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	

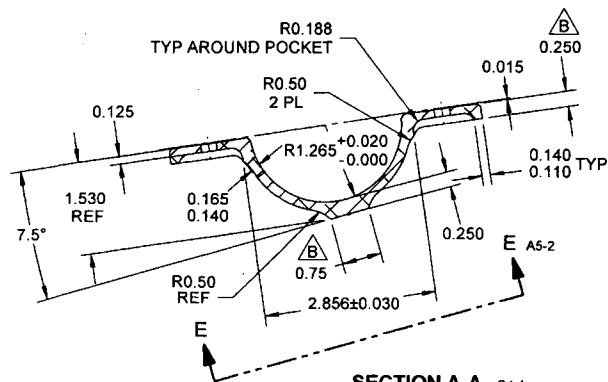


RELEASED
01/07/15/14

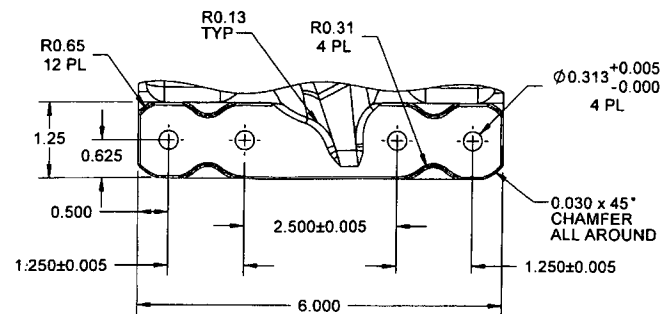
SECTION D-D B6-1

- NOTES:**
- (B)** 1) MATERIAL: 7075-T7351 ALUMINUM PER QQ-A-250/12 OR AMS-QQ-A-250/12 OR
AMS-QQ-A-250/12 (REF DART SPEC. D6101-017)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO
MAX. DEPTH OF 0.010 WITH A MIN. TOOL RAD OF R0.010
- 7) WEIGHT: 0.71 lbs

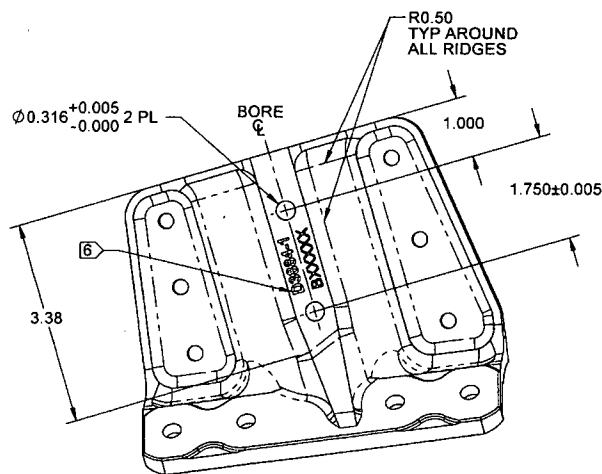
B	D6101-017 WAS D6102-017, ZN A6-1; ADD NOTE, ZN C4-2: ADD R0.031, ZN C2-2: INCREASED TOLERANCE 0.175 WAS 0.165, ZN B7-1, ADD 0.615, ZN C6-1, ADD 0.648, ZN C4-1: ADD 0.250, ZN D6-2; ADD 0.060, ZN C2-2; 0.75 WAS 0.65, ZN D7-2		RF	09.06.30
A	NEW ISSUE		RF	09.03.30
REV.	DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.		
DRAWN	RF	PORT HADLOCK, WA		
CHECKED		DRAWING NO.	REV.	
MFG. APPR.		D3884	SHEET 1 OF	
APPROVED		TITLE	SCALE	
DE APPR.		INBOARD SADDLE	NT	
DATE	09.06.30			
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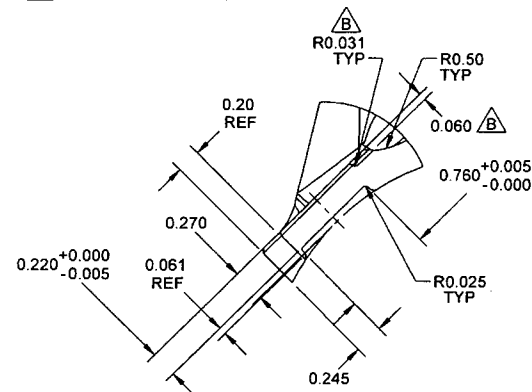
SECTION A-A C4-1



VIEW B-B B3-1
(ROTATED FOR CLARITY)



VIEW E-E C6-2



DETAIL C B3-1
SCALE 2X

RELEASED
09/15/10

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.		D3884	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		INBOARD SADDLE	NTS
DATE	09.06.30	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	